



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4634-143
Job Sheet 167077-E



Part No: D4634-143

Job Qty: 1 ea

Part Name: Middle, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start up container	2017-12-14 JML
100	HandThermo	1 pcs		11/9/17	0.00	1.65	HandFinish4	D.M.L
110	Small Fab	1 pcs		11/10/17	0.00	1.47	Small Fab	D.M.L
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	17-12-27
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	D.M.L
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4634-143 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # _____ Expiry Date _____ 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: _____

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	- D4634-3 5021679	1	2	0	0
	- D4636-5 5021677	2	43	0	0
	- D4647-1 5021676	1	4	0	0
	- D4664-5 5021675	6	39	0	0
	- D4712-1 5021674	2	4	0	0
	- D4732-21 5021673	1	6	0	0
	- D4732-25 5021672	1	7	0	0
	- D5021-3 5021671	1	2	0	0
	- MPNY-750S-9-C 5021670	3	570	0	0
	- MS20426AD3-4 5021669	4	5,055	0	0
	- MS20426AD4-6 5021668	4	2,797	0	0
	- MS21059L08 5021665	2	62	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com		Mfg Date: 12/14/17 Job No: 167077 - E		AGAINST DEPARTMENT/PROCESS					
Part No. _____						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. _____						Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
Date: _____						Forming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
						Large Fab ☐		Composite ☐	Supplier ☐	MRB (QSI042) Approval	
						QTY Effective: _____					
						Disposition					
										Completed By	
										Lead hand / Supervisor Approval Verification	
										QC / QA Coordinator Approval	
						FAULT CATEGORY					
Root		Environment ☐		Temperature/Cure ☐		Power Loss/Surge ☐		Positioned Wrong ☐			
Design ☐		Doc/Data ☐		Route ☐		Folio/Program ☐		Outside Dimensions ☐			
Equip/Tooling ☐		Handling/Pre ☐		/Damage/Defect ☐		Grain ☐		Over/Under tolerance ☐			
Material ☐		Internal Transport ☐		ion Incomplete/Unqualified ☐		Weld ☐		Part Incorrect ☐			
Tribal Knowledge ☐		LOA ☐		ination ☐		Wrong Stock Pulled ☐		Part Lost/Missing ☐			
Substation ☐		Past Expiry Date ☐		rsink ☐		Out of Sequence ☐		Part Moved ☐			
Misidentified ☐		Misidentified ☐		Short ☐		Off-set ☐		Drawing ☐			
		Process Improvement ☐		Instructions Incomplete/Unclear ☐		Mislabeled ☐		Finish ☐			
		Manufacturing Process ☐		Drill Holes ☐		Fit/Function ☐		Misread ☐			
		Past Due ☐		OTHER: _____		Misaligned/off center ☐		Turning Sequence ☐			

Middle, Center Ceiling Replacement Panel Assembly

D4634 - 143

Packaging

PART NO:

Revision:

Operation:

Change No:

S021696